

STAVIS SEAFOODS, INC.

STANDARD OPERATING PROCEDURES — LINE AND EQUIPMENT OPENING / OIL DRAINING PROCEDURE

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| | 5. When possible use system suction to evacuate the line/ equipment. If the line/equipment is not connected to a suction line, then using a hose properly approved, verified to be with in date and is for ammonia service work to the low suction side of the system, and evacuates the residual liquid ammonia. | |
| | 6. After most of the frost has disappeared and the gauge reads zero psig, the liquid should be gone from the line/ equipment. Close the valve and then remove hose, then reopen the hand valve to the atmosphere to verify there is no vapor present. Leave the valve port open and install tag showing valve is open so no pressure can rebuild in line/equipment. | |
| | 7. When you have proven there is no residual vapor present in the line/equipment by open the valve port to the atmosphere, the work or procedure may begin. | |
| | 8. After maintenance or procedure is complete, slowly and carefully, allow gas only from the suction side or hot gas line to flow into the line/equipment so any leaks can be detected prior to introducing any liquid ammonia back into the line/equipment. Remove all safety tags place all valves back into the open position and follow any associated SOP startup procedure that may be involved. | |

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| Oil trap draining procedures | 1. As the ammonia is compressed and the gas flows out to the system there will be a certain amount of compressor lubrication oil transferred into the refrigeration system piping. The oil draining procedure is necessary to maintain system efficiency and integrity. By system design there are oil collection points at which oil can be retrieved. This procedure provides a guideline to ensure that draining oil from pot is done safely, with minimal ammonia release to the atmosphere. | This is a common occurrence in a mechanical refrigeration system and this procedure, while done on a periodic basis, still needs to be handled with great caution, as the system will be under pressure. As always, treat ammonia with respect. |
| | 2. There are numerous locations where oil pot will need to be drained on a regular basis. Most of these locations will be found on the "low pressure" side of our system. This means that there should only be approximately 30 pounds of ammonia pressure pushing the oil out of the system. Pay close attention to the frost or the lack of frost on the oil collection pot. When there is no frost present, this indicates the pot is full of oil and requires draining. Note that when the pot is empty the pot will be completely covered with frost and does not require draining. | Verify that your system oil drain pots have safety relief valve protection installed. Never isolate oil pots that are not equipped with a safety relief valve. |